

# Work Order ID 51221

August 10, 2009 3:40:16 PM



Page 1

Item ID: D2562-001

Accept



Setup Start



Revision ID: D

Stop



Item Name: Strut

Start Date: 8/10/09 Start Qty: 6.00



Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *CZ*

Date: *07/08/10* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2562

Rev D

100

0.00



NC BRAKE

0.00

Brake NC

Memo

Brake NC

Punch to length as per Dwg D2562

*M-L 09/08/11*

110

0.00



Small Fab

0.00

Small Fab

Memo

Small Fab

1- Bend end as per Dwg D2562 Angle "D" 2-Deburr

*M-L 09/08/11*

*(6X)*

120

0.00



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

*2) S or lost*

*6X*

# Work Order ID 51221

August 10, 2009 3:40:16 PM



Page 2

Item ID: D2562-001

Accept



Setup Start



Revision ID: D

Stop



Item Name: Strut

Start Date: 8/10/09 Start Qty: 6.00



Cust Item ID:

Required Date: 8/14/09 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:30 AM

OVEN TEMPERATURE:

12:00 PM

FINISH TIME:

400°F

⇒ Jsl

09-08-12

(X6)

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

⇒ S or 8/12

(X6) f

150

Identify as per dwg & Stock Location:

264

0.00



Packaging

Memo

0.00

Packaging

MD 09/08/13

(X6)

# Work Order ID 51221

August 10, 2009 3:40:17 PM



Page 3

Item ID: D2562-001

Revision ID: D

Item Name: Strut

Start Date: 8/10/09 Start Qty: 6.00

Required Date: 8/14/09 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/08/18

09-08-14

09/08/13

# Picklist Print

August 11, 2009 11:22:41 AM

Page 1 / 1

Work Order ID: 51221



Parent Item: D2562-001RevD



Parent Item Name: Strut

Start Date: 08/10/2009

Required Date: 08/14/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	283.0441	10.7792			

304 RD Tube .500 x .035W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

283.0441097

108250

2.23

111097

24.687936

111704

31.6682737

112187 ✓

224.4579

M 112187  
M-L 09/08/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

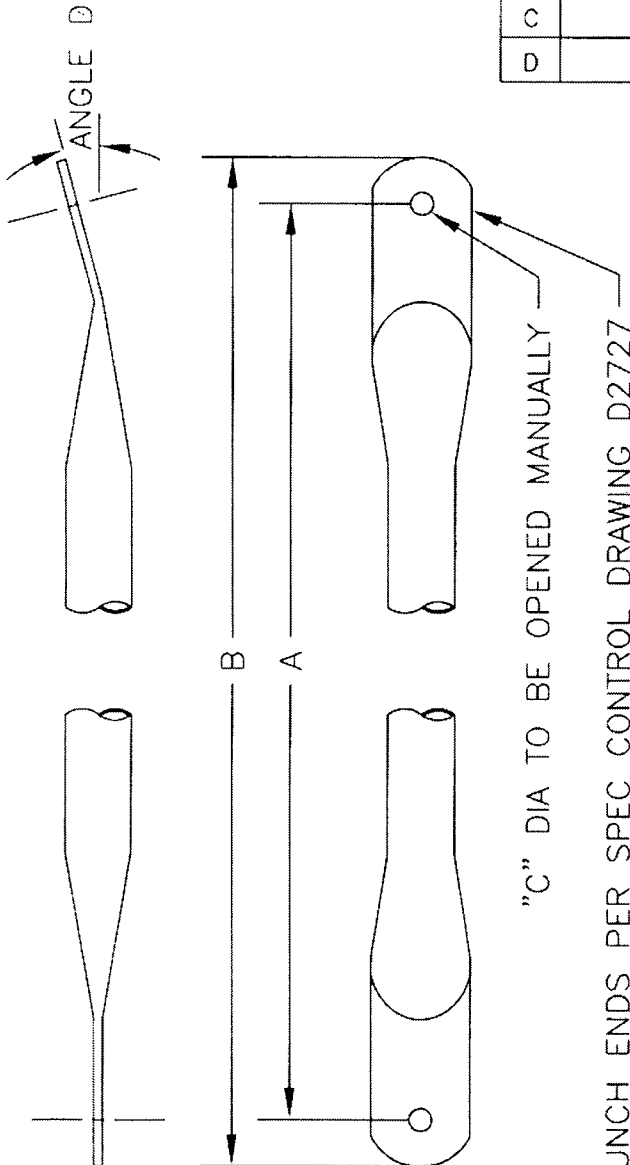
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CP	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2562	REV. D SHEET 1 OF 1
DATE 05.05.18		TITLE STRUT	SCALE 1:2
A	96.05.01	NEW ISSUE	
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)	
C	02.06.05	ADD -005; ADD FINISH	
D	05.05.18	ADD -007/-011/-013; UPDATE -005	



PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

C20768110  
W10: 51221

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TRO.500W.035) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

Copyright © 1996 by DART AEROSPACE LTD

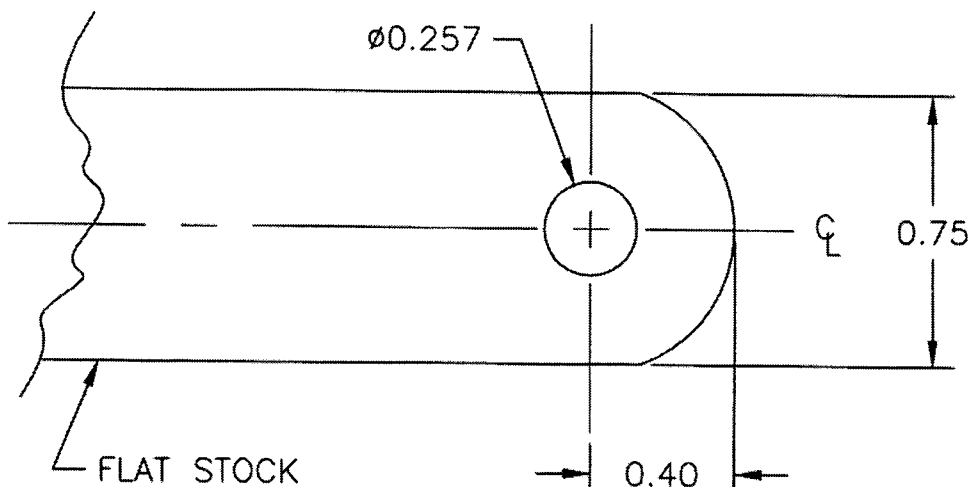
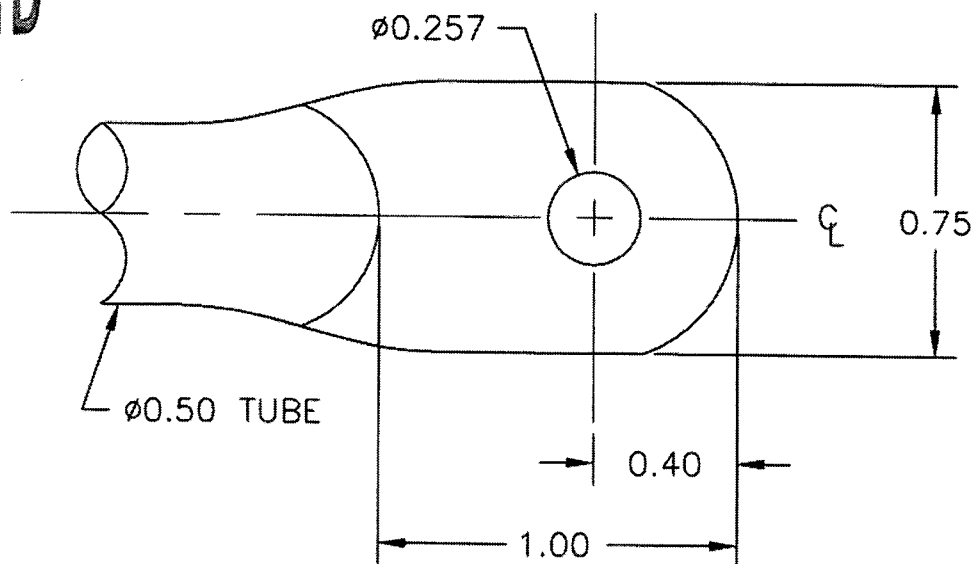
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	#CP 01.12.20	ADD TOLERANCE NOTE	

## SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

**RELEASED**  
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries